

DART AEROSPACE LTD	Work Order:	24274
Description: Strut	Part Number:	D2565-103
DT 04.04.06 DTF 05.05.06		

Drawing: D2565 Rev.01, D2638 Rev. A

Qty: 20

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	BB	05.09.14	20
2	METAL	Punch 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall to length as per Dwg D2565 using DT 8313 Batch M10540 H10457	FF	05.10.14	20
3	METAL	Drill hole open to .3125" as per Dwg D2565 (one end only) Ø 0.316 RF 04.12.07	PL	05/11/03	20
4	METAL	Deburr	DL	05/11/03	20
5	QC	Inspect Level 5	CD	05.11.07	20
6	FINISHING	Powder Coat White (Ref 4.3.5.2) as per QSI 005 4.3	MM	05/11/28	20
7	QC	Inspect Level 3	CD	05/11/25	20
8	STORES	Bag and Tag	CD	05/11/25	20
9	EXPEDITING	Inspect Level 21 Close W/O Cost / Part	5ur	05/11/28	20

Rev	Date	Change	Revised By	Approved
A	97.01.14	New Issue	KS	
B	98.10.29	Updated material, drawing revision	KS	
C	99.02.11	Added Inspection	DM	
D	99.06.16	Re-format	DM	
E	01.08.28	Added Powder coat, and added Inspection Levels 3 and 21.	SM	
F	02.04.16	Added dwg Rev.01 D RF 02/04/14	NG	02.05.14

RELEASED

02/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

Date: 05/11/28

NOTE: Date & initial all entries

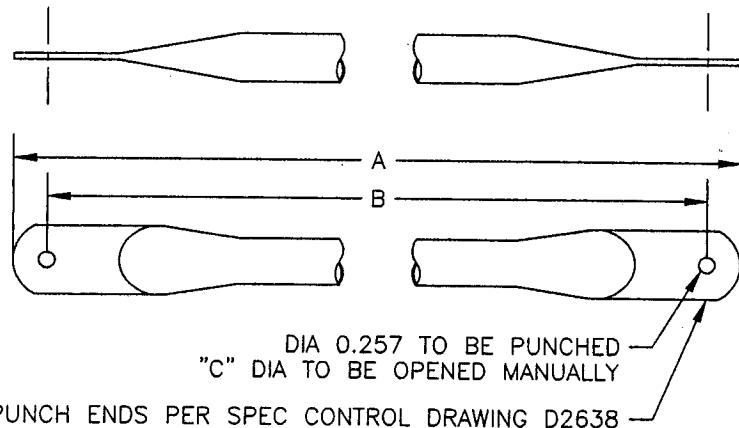
QA: N/C Closed: _____

Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

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GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALLUM (REF. DART SPEC. M304TR0.750W0.049) SL T1 ENDMENT ENSURE SEAMLESS TUBE IS USED FICUT NOTICE
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER
- 4) ALL DIMENSIONS ARE IN INCHES NO. 24274

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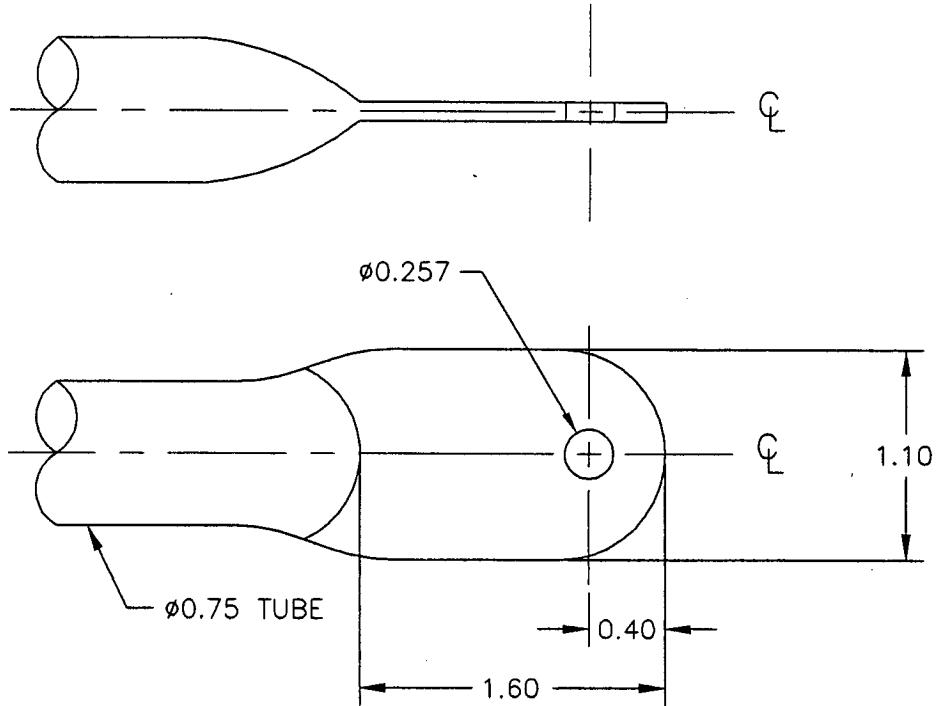


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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DMM	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
4/6/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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WITHOUT NOTICE

WORK ORDER

NO. 24274

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 13, 2005
03:34 pm

Work Order No	:	0024274	Department Code:		
Project Name	:	D2565-103	Burden Flags	:	NNNNNNN
Project For	:	WK544	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D2565-103	Invoice Number	:	
Description	:	Strut	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	20	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	09-13-05	Est Mark Up	:	0.000%
Est Finish Date	:	10-30-05	Actual Mark Up	:	0.000%
Act Finish Date	:				
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:				
			\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
	=====	=====	=====		
Burden	:	0.00	0.00	0.00	
	=====	=====	=====		
Total Cost	:	0.00	0.00	0.00	
Mark up	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/(Loss)	:	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
HawkesburyNov 08, 2005
11:14 am

Work Order No : 0024274
 Project Name : D2565-103
 Project For : WK544
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2565-103
 Description : Strut
 Manufactured : Yes
 Amount Req'd : 20
 Amount Done : 0
 Start Date : 09-13-05
 Est Finish Date : 10-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	1.55	100.00		
Production Cost	0.00	23.95	100.00	0.00	23.95
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	23.95	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	23.95			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	(-23.95)

Mis 01/5
 u
 11.13

Date: Monday, 14/11/2005 8:40:54 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 24274					
Estimate Number	: 10275					
P.O. Number	:			Part Number	: D2565103	
This Issue	: 14/11/2005		S.O. No.	: D2565 REV E		
Prsht Rev.	: NC			Project Number	:	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	:			Drawing Revision	: E	
Written By	:			Material	:	
Checked & Approved By	:			Due Date	: 30/11/2005	
Comment	: Est: F02.04.16 Added dwg Rev.C1 NG			Qty:	20	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M304TR0750W049	304 RD Tube .750 x .049W			
2.0	BRAKE NC	NC BRAKE			
Comment: BRAKE NC					
Punch to length as per Dwg D2565 using DT8313					
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			
Comment: SMALL & MEDIUM FAB RESOURCE 1					
1-Drill hole open to .3125 Ø as per Dwg D2565 (one end only)					
2-Deburr					
4.0	QC5	INSPECT WORK TO CURRENT STEP			
Comment: INSPECT WORK TO CURRENT STEP					
5.0	POWDER COATING	POWDER COATING			
Comment: POWDER COATING					
Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3					
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION			
Comment: INSPECT POWDER COAT					
7.0	PACKAGING 1	PACKAGING RESOURCE #1			
Comment: PACKAGING RESOURCE #1					
Identify and Stock					
Location: _____					

Date: Monday, 14/11/2005 8:40:54 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 24274

Part Number: D2565103

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



